Wednesday, 23/04/2008 7:26:54 AM

User: Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 38739

Estimate Number

: 11645

P.O. Number

: 23/04/2008 This Issue

Prsht Rev.

: NC

First Issue **Previous Run**

Written By

Comment

: //

: 38743

Type

: Est B 02.03.06

S.O. No. :

: SMALL /MED, FAB

Added dwg Rev.B NG Est Rev:C 08-04-22 now on water jet DD verified by:

Drawing Number

Due Date

: D29921 D2992 REV A

: DOUBLER

Project Number

Drawing Name

Part Number

: N/A

Drawing Revision

Material

: 30/04/2008

Qty:

Each

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

5052-H32 .040 Sheet

1.0

M5052H32S040

Total:

0.4813 sf(s)

Comment: Qty.:

0.0802 sf(s)/Unit

5052-H32 .040 Sheet

Material: 5052-H32 0.040" sheet

Batch: 1783S

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2992

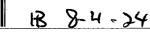
Dwg Rev:_

Prog Rev:

2-Deburr if necessary

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



_Page_1

Form: rprocess

Date:

Wednesday, 23/04/2008 7:26:54 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38739

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



7.0

PACKAGING 1

PACKAGING RESOURCE #1



chrabl



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



8.0

QC21



mr 08-04-28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date

Tuesday, 4/22/2008 3:11:02 PM

User: Chantal Lavoie **Process Sheet Drawing Name** : DOUBLER Customer : CU-DAR001 Dart Helicopters Services **Job Number** : 38739 **Estimate Number** : 11645 Part Number : D29921 P.O. Number : D2992 REV A : 4/22/2008 This issue S.O. No. : **Drawing Number** Prsht Rev. : NC : N/A **Project Number** : A First Issue : // Type : MACHINED PARTS **Drawing Revision** : 25941 Material **Previous Run** Qty: 6 Um: Each : 4/24/2008 **Due Date** Written By **Checked & Approved By** : Est B 02.03.06 Added dwg Rev.B NG Comment **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M5052H32S040 5052-H32 .040 Sheet 1.0 Comment: Qty.: 0.0802 sf(s)/Unit Total: 0.4813 sf(s)5052-H32 .040 Sheet Material: 5052-H32 0.040" sheet SHEAR SHEAR 2.0 Comment: SHEAR Make as perdwg D2992 Deburr TO CURRENT STEP 3.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING1 4.0 Comment: HAND FINISHING RESOURCE \$1 Chemical Conversion Coat as per QSI 005 4.1 PACKAGING RESOURCE #1 5.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

Dart Ae	rospace	Ltd							
W /O:			WC	RK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE B			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cateç	Jory: N	ICR: Yes	No DQ	A:	Date:	
								_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
D.4.T.E.	OTED	Description of NC	Corrective Action Section		Weritica:		cation	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

Date:,

*Tuesday, 4/22/2008 3:11:02 PM

Ušer: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38739

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER				
DATE	STEP	PROCEDURE CHANGE	By Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	<u> </u>	PAR #: Fault Category:	NCR: Yes No D		Date:	

QA: N/C Closed: ____ Date: ___

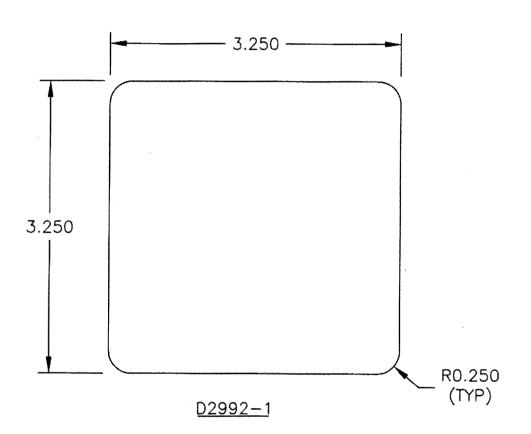
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B						
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
								1000		
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	5'				***					
						}		,		

NOTE: Date & initial all entries





DESIG	" CP	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHEC	ŒD #	APPROVED (DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE	HAVE CHANGE		TITLE	SCALE
02.0	1.21		DOUBLER	1:1
Α		02.01.21	NEW ISSUE	



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CZ08/04/22

W10:38739

DART AEROSP	ACE LTD	Work Order: 38739	
Qescription:	Doubler	Part Number: D 3992-1	
Inspection Dwg: D	3992-1 Rev: A	Page 1 of 1	_

FIRST ARTICLE INSPECTION CHECKLIST

∻:		X First Ar	ticle _	Pro	totype	
Drawin g Dimension	Tolerance	Actual Dimension	Accept	Rejec	Method of Inspection	Comments
3.250	4-010	3,247	*		·	
3.200	7- ,010	3.247 3.360	*			
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Measured by:	B	Audited by:	8	Prototype Approval:	J.	
Date:	8-4-24	Date:	08 ce/24	Date:		w
				<u> </u>	<u> </u>	

Rev)ate	Change	 Revised by	Approved
A		New Issue	KJ/JLM	

